

Date: Friday, 23/05/2008 9:53:09 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 39433		
Estimate Number	: 11965		
P.O. Number	:	Part Number	: D2054
This Issue	: 23/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2054 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 31219	Drawing Revision	: B
	Type : RMA	Material	:
Written By	:	Due Date	: 15/06/2008
Checked & Approved By	: <u>JL0085.23</u>	Qty:	100 Um: Each
Comment	: Est A1 03.01.21 Revise Dwg Rev B; added Black Teflon or Delrin; Made on Cobra RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRRNR1000	Delrin Round Bar 1"
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(104)



Comment: Qty.: 0.0612 f(s)/Unit Total: 6.1215 f(s)
 Delrin Round Bar 1"
 Mat: Black UHMW 1" dia or black Teflon or Black Delrin
 Batch M 104346

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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(104)



Comment: HARDINGE CNC LATHE SMALL
 Machine as per folio FA
 Deburr

DIP/MME 08/05/24

(104)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP/MME 08/05/24

(104)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M 08/05/25

(104)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 8-9

08/05/26 (104)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:53:09 AM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 39433

Part Number: D2054

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

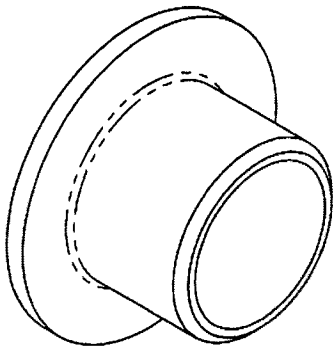
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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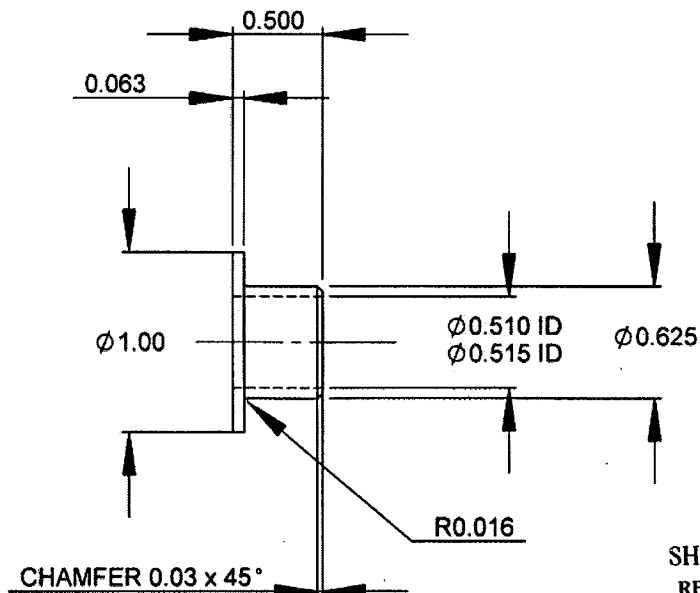


DESIGN JB	DRAWN BY LP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2054	REV. B SHEET 1 OF 1
DATE 01.12.20		TITLE BUSHING	SCALE 1:1
--	92.05.13	NEW ISSUE	
A	01.06.05	CHANGE TOL. ON ID.	
B	01.12.20	REDRAW; ADD DELRIN OPTION; ADD NOTES	

RELEASED
01.12.21



ISOMETRIC DETAIL (SCALE 2:1)



D2054 BUSHING

MATERIAL: BLACK TEFLON
or BLACK UHMW
or BLACK DELRIN

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39433

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